

Date: Monday, 7/30/2007 1:54:11 PM

User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPAD	
Job Number	33799				
Estimate Number	12785				
P.O. Number	N/A		Part Number	D356411	
This Issue	7/30/2007	S.O. No.	S.O. No.	N/A	
Prsht Rev.	NC		Drawing Number	D3564 REV C	
First Issue	N/A		Project Number	N/A	
Previous Run	33455		Drawing Revision	C	
Written By			Material	N/A	
Checked & Approved By			Due Date	8/28/2007 Qty: 12 Um: Each	
Comment					
	Est Rev:A	New Issue 07-03-08 ec			
	Est Rev:B	As per Rev C 07-07-09 JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 
Comment: Qty.: 0.9177 sf(s)/Unit Total : 11.0124 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>m105061</u> FB 07-07-31		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)**** Dwg Rev: <u>C</u> FB 07-07-31 Prog Rev: <u>C</u> 2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  B 07-07-31		
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK  En 07/07/31 Y/2 Counted		
5.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT  FF 07-08-08 12		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: D2 Date: 07/08/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 33799		Part Number: D356411
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP Ensure joggle as per dwg D3429		<i>Er 07/08/08 x 12 (counter)</i>
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R 2059B Hardcoat <u>M105138</u> Weld hardcoat as per Dwg D3437		<i>fc 07/08/19 (12)</i>
8.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<i>07/08/19 (12)</i>
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>07/08/20 (12)</i>
10.0	POWDER COATING	POWDER COATING  <i>m 104846</i>
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		<i>Fx 07/08/21 (12)</i>
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>M-1 07/08/21 (12)</i>
12.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>Identify and Stock Location: DFP-14</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: DFP-14		<i>BR/MB/ 07-08-21 (12)</i>
13.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>ND 07/08/20 (12)</i>
Job Completion		

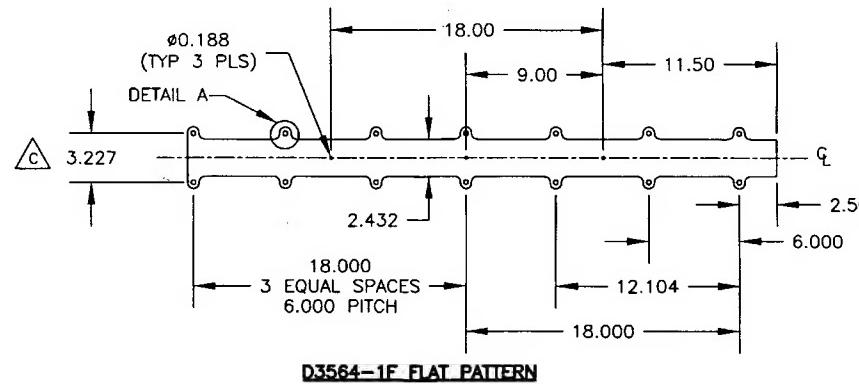
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

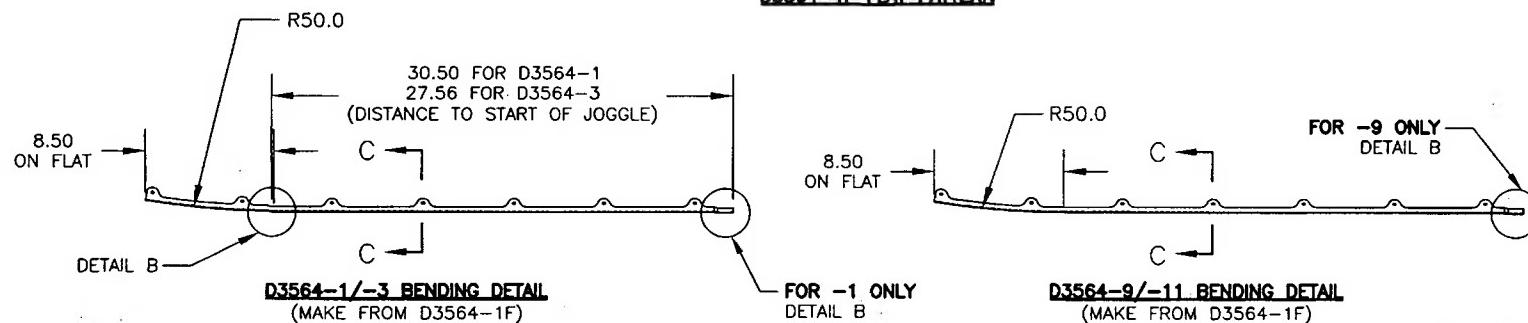
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**



2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

**D3564-1/-3/-9/-11 WELDING DETAIL**

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3379  
ENGINEERING  
RETURN TO  
SHOP COPY

**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

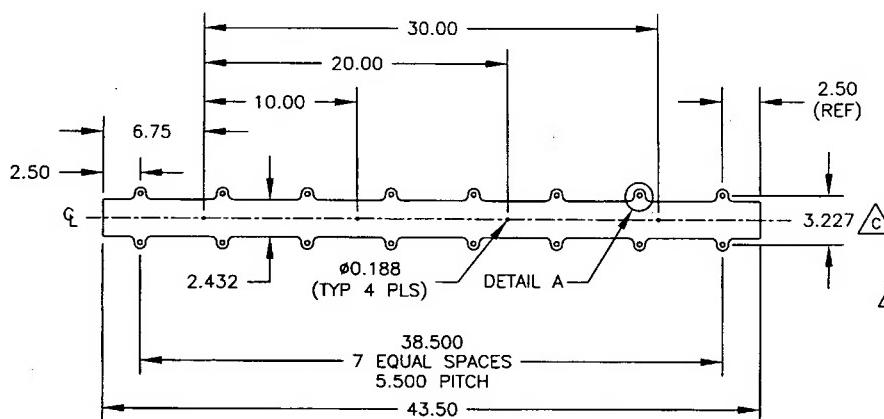
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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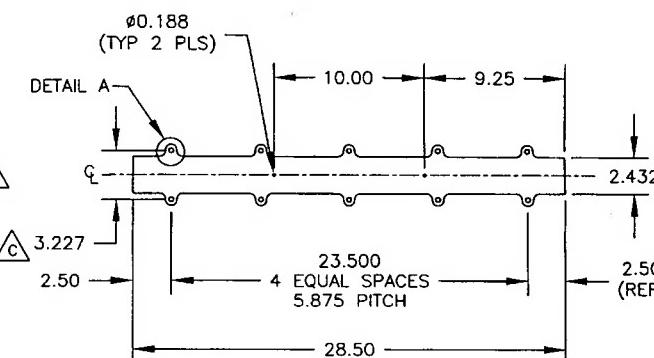
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> HANCOCK, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3564 REV. C SHEET 1 OF 2
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:8

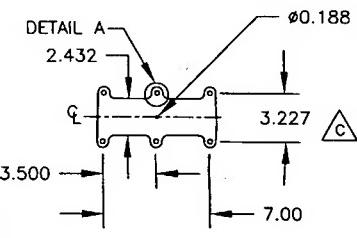
**RELEASED**  
07.06.28



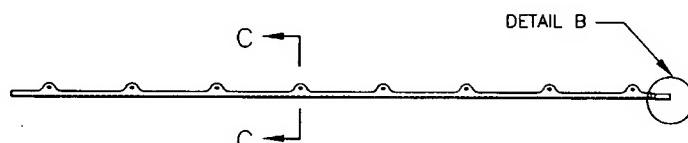
**D3564-5F FLAT PATTERN**



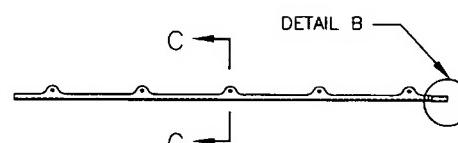
**D3564-7F FLAT PATTERN**



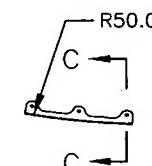
**D3564-13F FLAT PATTERN**



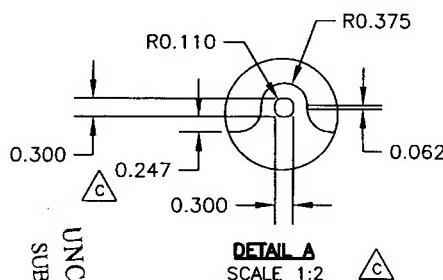
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



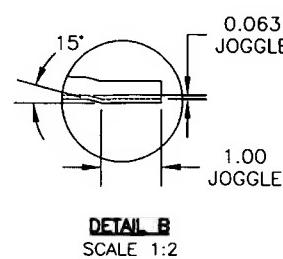
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



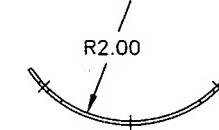
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



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ENGINEERING RETURN TO SHOP COPY



SECTION C-C  
SCALE 1:2



DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED		REV. C
		D3564	SHEET 2 OF 2
DATE	TITLE		SCALE
07.04.17	WEARSHOE		1:8

RELEASED  
07.04.2017

DART AEROSPACE LTD	Work Order:	33799
Description: WEAR PAD	Part Number:	J3564-11
Inspection Dwg:	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	SP	Prototype Approval:	W/A
Date:	07-07-31	Date:	07/07/31	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	